

5/31/2018

[Dart Hawkesbury] Job Sheet - White, Jesse



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

2

D3391-015
Job Sheet 178461



Part No: D3391-015

Job Qty: 1 ea

Part Name: Aft Tube Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: High

Job Created: 5/31/18

Job Tracking No:

Due Date: 6/29/18

Created By: Jesse White

Type: SOLD

Description:

Note: DWG REV J SHEETS 8,10,11 IPP rev A 05.12.13 New issue EC IPP rev B 06.02.09 Dwg @ revD EC IPP rev C 07.03.13 dwg @revF ec IPP rev D 07.10.31 ecn 1053P EC IPP Rev:E ECN 1056 07-11-13 DD verified by: EC IPP Rev:F 08-09-10 revH as per dwg DD verified by:EC IPP Rev:G 11.11.14 AS PER REV.I DD verified by:JLM

Ship Via:

Bill of Materials

Plex 5/31/18 2:24 PM dart.white.jesse



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Container No: S079245



Part: D3391-015

Job No: 178461

Serial No/Batch: S079245

Revision:

Inspector:

Exp Date: 06/08/2018

Instructions:

Date: 06/08/18

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	6/29/18	6/29/18	0.00	0.00	Start Up Crosstubes		M.D. 2018-06-08
100	Mori Seiki	1 pcs	6/29/18	6/29/18	3.56	5.56	Mori Seiki TL-40		M.D. 2018-06-11
110	QC	1 pcs	6/29/18	6/29/18	0.00	0.00	QC2-1		M.D. 2018-06-11
120	CNC Vertical Machining	1 pcs	6/29/18	6/29/18	0.00	2.57	HAAS1-3		M.D. 2018-06-11
130	QC	1 pcs	6/29/18	6/29/18	0.00	0.00	QC2 Machining-2		M.D. 2018-06-11
140	QC	1 pcs	6/29/18	6/29/18	0.00	0.00	QC8 Machining-2		M.D. 2018-06-13
150	Skidtubes	1 pcs	6/29/18	6/29/18	0.00	2.07	Skidtubes-3		M.D. 2018-06-13
160	CNC Bend Skidtubes	1 pcs	6/29/18	6/29/18	0.00	2.57	CNC Bend Crosstube		M.D. 2018-06-13
170	QC	1 pcs	6/29/18	6/29/18	0.00	0.00	QC5		M.D. 2018-06-13
180	Skidtubes	1 pcs	6/29/18	6/29/18	0.00	2.07	Skidtubes-4		M.D. 2018-06-13
190	QC	1 pcs	6/29/18	6/29/18	0.00	0.00	QC5		M.D. 2018-06-13
200	HandFinish	1 pcs	6/29/18	6/29/18	0.00	0.60	HandFinish1		M.D. 2018-06-13
205	QC	1 pcs	6/29/18	6/29/18	0.00	0.00	QC7-2		M.D. 2018-06-13
210	Skidtubes	1 pcs	6/29/18	6/29/18	0.00	2.07	Skidtubes-4		M.D. 2018-06-13
220	QC	1 pcs	6/29/18	6/29/18	0.00	0.00	QC5		M.D. 2018-06-13
225	HandFinish	1 pcs	6/29/18	6/29/18	0.00	0.60	HandFinish2		M.D. 2018-06-13
230	SprayPaint	1 pcs	6/29/18	6/29/18	0.00	0.63	Spray Paint		M.D. 2018-06-13
240	QC	1 pcs	6/29/18	6/29/18	0.00	0.00	QC14		M.D. 2018-06-13
250	HandFinish	1 pcs	6/29/18	6/29/18	0.00	0.60	HandFinish4		M.D. 2018-06-13
260	QC	1 pcs	6/29/18	6/29/18	0.00	0.00	QC5		M.D. 2018-06-13
270	Packaging	1 pcs	6/29/18	6/29/18	0.00	0.00	Packaging3-1		M.D. 2018-06-13
280	QC21-SA	1 Ea	6/29/18	6/29/18	0.00	0.00	QC21		M.D. 2018-06-13

Part Op 100 - Turn as per Folio FA599 Rev: J & Dwg D3391 Rev: J ****REMOVE STEADY REST AND MACHINING
 Descriptions: MARKS****

120 - 1-Machine as per Folio FA 599 Rev: J & Dwg D3391 Rev: J 2-Deburr

150 - 1-Drill (PILOT HOLE) aft cap holes per Dwg D3391 using DT8803 **Add tangent as per Folio-11**

160 - Form as per Dwg D3391 **Folio -11**

180 - 1- Open Aft cap pilot hole to .208" as per Dwg D3391 2-Drill float bag holes using DT8809 as per Dwg D3391 (All holes) 3-Drill wearplate holes as per Dwg D3391 using DT8878(Mid Tube) & DT8217 Wearplate Jig . *****Do Not Open To Finished Size***** 4-Drill Wearshoe holes as per DWG D3391 using DT8939 locating from 2 previously drilled aft wearplate holes. 5- Tranfer holes from D3391-013 for electric step 0.187" hole D3391 section cc-cc 6- Using DT10247 and drill holes for nutplates, Detail DD, open (5) forward wearplate holes 0.375", and c'sink 7-Open wearplate holes to 0.297" and c'bore as per dwg D3391. ***SIX FARTHEST AFT HOLES ONLY*** 8-C'bore section cc-cc and open to finish size 9- Open float bag holes to 0.328" as per Dwg D3391, and c'sink 10-Deburr

210 - 1- Instal spacers as per dwg D3391 A/R Magnabond 6398 Batch: 1137072 exp. date: 08-18 cure time 12hrs as per QSI0015 2- Grind crossbolts flush 3- Back drill using #9 drill 4- Touchup Magnabond 5- Deburr

225 - REALODINE AS PER PAR09-043

230 - PRIME AS PER DWG AND QSI005 4.2.1.3.3 PRIMER BATCH: 138862 PAINT AS PER DWG AND QSI005 4.2.2.4 PAINT: 138886

250 - 1- Install nutplate using MS20601AD4W4 (qty12) in the six most forward holes and MS20601AD4W9 (qty8) in the four aft holes. Rivet nutplates as per section TT on sheet 11. 2-Install inserts per dwg D3391 3-Install Aft Cap as per Dwg D3391 A/R Sikaflex-241/-291 1413072 Sikaflex expiry date: 10/11 4- INSTALL WEARPLATE AS PER DWG

B139427

Job BOM

004480

Part / Item	Component Name	Quantity	Operation	Container
D6014-090	Aluminum Extrusion	1 Ea (1 ea)	90-Start up Operation	505643
NAS1149C0332R	Washer	10 Ea (10 ea)	90-Start up Operation	
D3670-4-200	Bushing	14 Ea (14 ea)	210-Skiddtubes	5077425
ALS4-1032-130	Rivnut	8 Ea (8 ea)	250-HandFinish	5007279
ALS4-1032-225	Rivnut	4 Ea (4 ea)	250-HandFinish	5058138
ALS4-428-165	Insert	4 Ea (4 ea)	250-HandFinish	5058145
AN3C4A	Bolt	6 Ea (6 ea)	250-HandFinish	5068642
AN3C5A	Bolt	4 Ea (4 ea)	250-HandFinish	0037153
D2646	Aft Cap	1 Ea (1 ea)	250-HandFinish	F165010
D3672-1	Washer, Phenolic	2 Ea (2 ea)	250-HandFinish	F156070
D4095-047	Wearpad Aft	1 Ea (1 ea)	250-HandFinish	5025094
D4095-049	Wearpad Aft	1 Ea (1 ea)	250-HandFinish	5078290
MS20601-AD4W3	Rivet	12 Ea (12 ea)	250-HandFinish	5006193
MS20601-AD4W7	Rivet	8 Ea (8 ea)	250-HandFinish	m137148
MS21075L5	Nut Plate	10 Ea (10 ea)	250-HandFinish	5004858

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D6014-090	1	21	0
	NAS1149C0332R	10	6,681	0
210-Skiddtubes	D3670-4-200	14	32	0
250-HandFinish	ALS4-1032-130	8	13,829	0
	ALS4-1032-225	4	4,997	0
	ALS4-428-165	4	108	0
	AN3C4A	6	1,908	0
	AN3C5A	4	1,947	0
	D2646	1	90	0
	D3672-1	2	1,088	0
	D4095-047	1	27	0
	D4095-049	1	36	0
	MS20601-AD4W3	12	1,307	0
	MS20601-AD4W7	8	169	0
	MS21075L5	10	454	0

Part Specifications

Specifications could not be found.

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②

DART AEROSPACE LTD		Work Order: 178461
Description: Float Skidtube (412)		Part Number: D3391-3
Inspection Dwg: D3391	Rev: J	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Lathe Section						
14.000	+/-0.010	14.00	✓		Tape	
3.500	+/-0.010	3.503	✓		Vern 08	
Ø3.200	+/-0.010	3.201	✓		BLM 4" 05	
Ø3.750	+/-0.010	3.753	✓		"	
30° x 0.060 chamfer	+/-0.010	.060	✓		Vern 06	
88.93	+/-0.030	88.93	✓		Tape	

Measured by: M.D. PMP	Date: 2018-06-07
Audited by: RB	Date: 18-06-08

HAAS Section						
1.526	+0.000/-0.030	1.500	✓		Vern H-08	
7.500	+/-0.010	7.498	✓		"	
27.750	+/-0.010	27.750	✓		H-tape	
31.750	+/-0.010	31.750	✓		"	
35.250	+/-0.010	35.250	✓		"	
3.300	+/-0.010	3.300	✓		Vern H-08	
0.200	+/-0.010	.200	✓		"	
3.520	+/-0.010	3.520	✓		"	
0.687	+0.010/-0.000	.688	✓		"	
R0.062	+/-0.010	R.062	✓		"	
Ø0.484	+0.005/-0.001	Ø.485	✓		"	

Measured by: MK	Date: 18/06/11
Audited by: DAS	Date: 18-06-13

Rev	Date	Change	Revised by	Approved
A	06.04.24	New Issue P/O D3391-015/-025	KJ/JLM	
B	06.06.19	Dwg revision update	KJ/JLM	
C	07.04.20	Ø0.208 dimension removed	KJ/JLM	
D	07.09.06	0.400 dimension removed	KJ/JLM	
E	07.11.23	Dwg Rev. updated	KJ/EC/DD	
F	09.04.27	Dimensions updated per Rev H and NCR09-028	KJ/JLM	
G	09.11.16	Dimension 0.200 removed	KJ	
H	11.06.21	Dimension 44.995 removed	KJ	
I	12.05.15	Dwg Rev updated	KJ	
J	12.05.23	Dimension updated	KJ	
K	12.10.15	88.93 dimension removed	KJ	
L	12.11.28	88.93 dimension added	KJ	
M	16.06.23	Dimensions updated per Rev J	KJ	

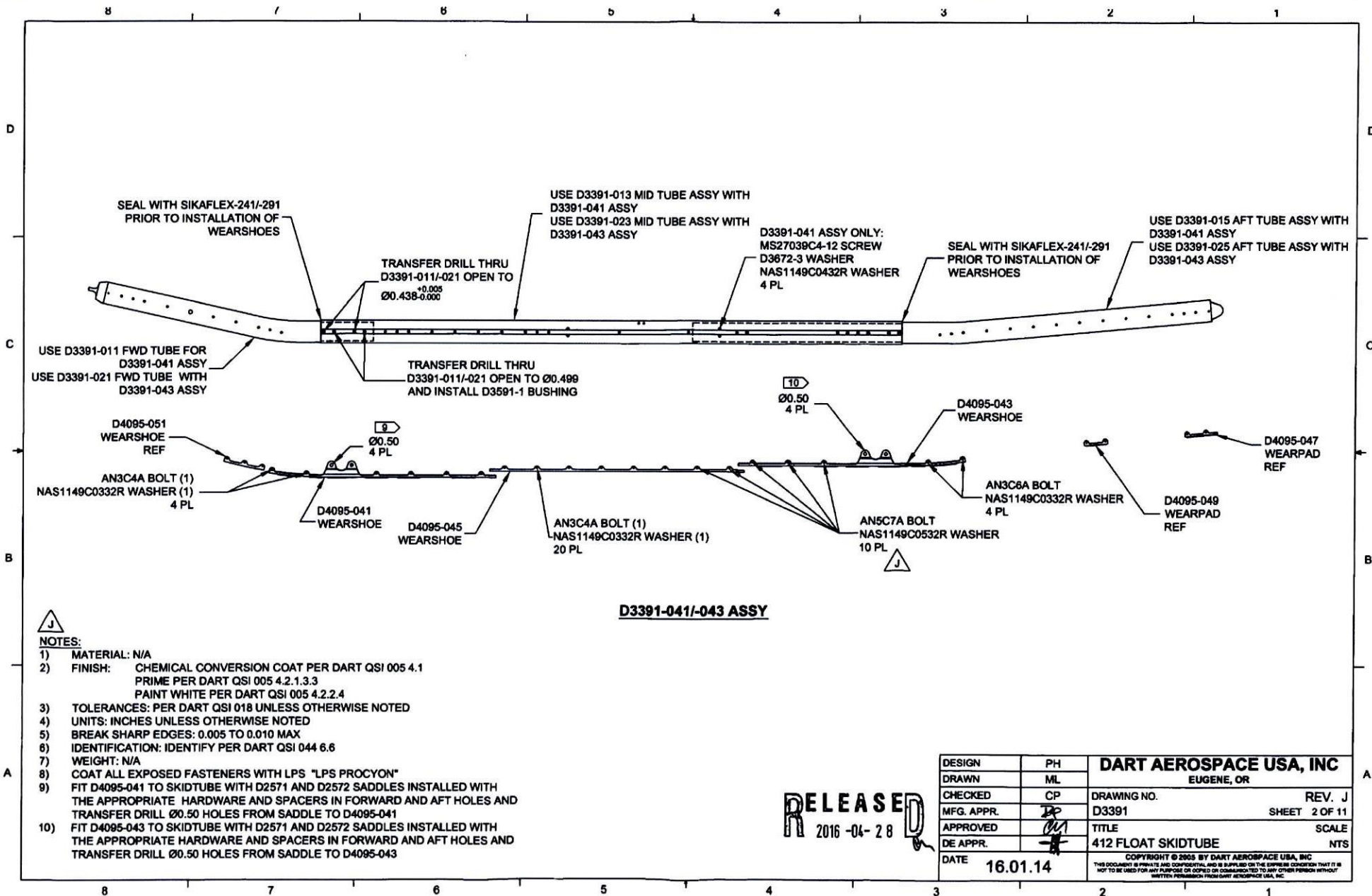
D3391-041/-043 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

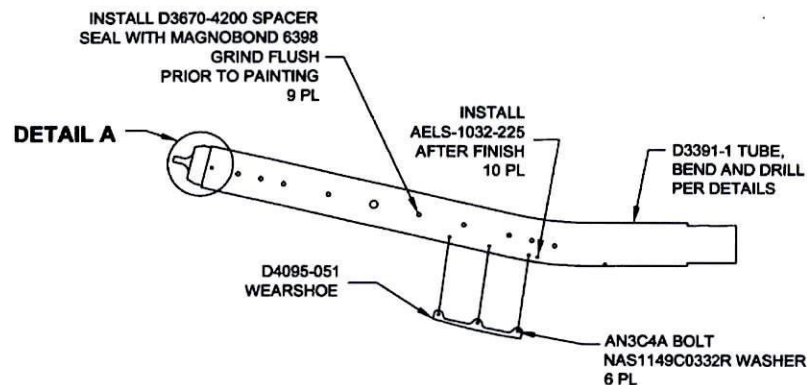
QTY -041	QTY -043	PART NUMBER	DESCRIPTION
X		D3391-041	FLOAT SKIDTUBE ASSEMBLY
	X	D3391-043	FLOAT SKIDTUBE ASSEMBLY
1		D3391-011	FWD TUBE ASSEMBLY
1		D3391-013	MID TUBE ASSEMBLY
1		D3391-015	AFT TUBE ASSEMBLY
	1	D3391-021	FWD TUBE ASSEMBLY
	1	D3391-023	MID TUBE ASSEMBLY
	1	D3391-025	AFT TUBE ASSEMBLY
2	2	D3591-1	BUSHING
4		D3672-3	WASHER
1	1	D4095-041	WEARSHOE
1	1	D4095-043	WEARSHOE
1	1	D4095-045	WEARSHOE
1	1	D4095-047	WEARPAD
1	1	D4095-049	WEARPAD
1	1	D4095-051	WEARSHOE
24	24	AN3C4A	BOLT
4	4	AN3C6A	BOLT
10	10	AN5C7A	BOLT
28	28	NAS1149C0332R	WASHER
10	10	NAS1149C0532R	WASHER
4		MS27039C4-12	SCREW
4		NAS1149C0432R	WASHER



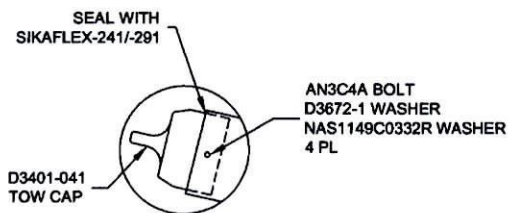
J	INCORPORATED DSI 9733, REFORMAT DRAWING CHANGED CBORE DEPTH (ZN D2-8, D2-9), REVISED TABLES, REPLACED POWDER COAT WITH PAINT	ML	18.01.14
I	REMOVE GASKETS AND REPLACE ALL WEARSHOES; PARTS LIST UPDATE, ZN A8-1, ZN A8-2, ZN A8-4, ZN B6-8; LPS-3 COATING REMOVED FROM NOTE 2, ZN A3-1, ZN A3-2, REMOVED INSERT AELS-1032-130, ZN B6-4, B2-4, C7-8, C3-8; REMOVED HOLES, ZN D6-4 ZN D2-4, ZN D7-8, ZN D3-8	XDF	11.10.13
H	DRAWING UPDATED TO CURRENT STANDARDS. SHT 1 PL ADDED D3591-1 BUSHING. ZN C6 Ø0.438 DIM WAS 4 PL. ADDED Ø0.499 DIM AND D3591-1 BUSHING. SHT 2 PL ADDED D3591-1 BUSHING. ZN C6 Ø0.438 DIM WAS 4 PL. ADDED Ø0.499 DIM AND D3591-1 BUSHING. (FOR FURTHER INFO SEE DSI 9384 & NCR 08-074)	AJS	08.08.20
G	REPLACE NAS INSERTS W/ AELS INSERTS SWITCH TO D3670-XXXX SPACERS FOR INSTALLING FLOAT BAGS, DWG REORGANIZED FOR CLARITY	DC	07.07.31
F	ADD SS WEARSHOE, GASKET REMOVE FWD SADDLE HOLE -011/-021	PH	07.01.18
E	CHANGE TOLERANCE, EASE MANUFACTURE	PH	08.04.25
D	UPDATE TOLERANCE, CHANGE HOLE SIZE	PH	08.01.23
C	LENGTHEN AFT EXTENSION	PH	05.09.27
B	DRAWING UPDATES	PH	05.06.10
A	NEW ISSUE	PH	05.02.07
REV	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE USA, INC EUGENE, OR	
DRAWN	ML		
CHECKED	CP	DRAWING NO.	REV. J
MFG. APPR.	LP	D3391	SHEET 1 OF 11
APPROVED	EP	TITLE	SCALE
DE APPR.	EP	412 FLOAT SKIDTUBE	NTS
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2016-04-28
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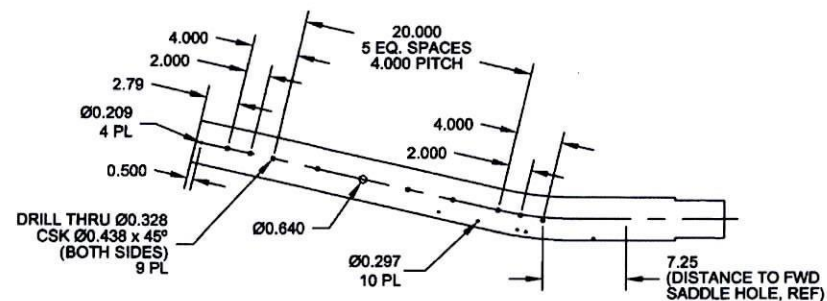




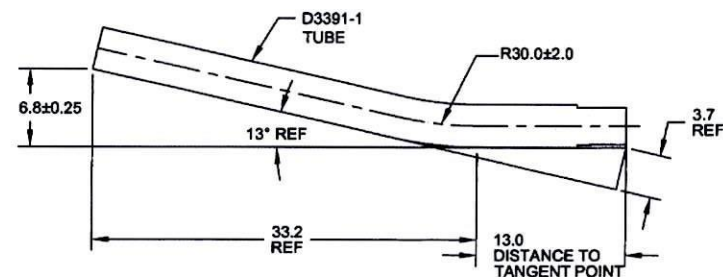
D3391-011 FWD TUBE ASSEMBLY
ASSEMBLY DETAIL



DETAIL A
SCALE 2X



D3391-011 DRILLING DETAIL



D3391-011 BENDING DETAIL
(MAKE FROM D3391-1)

D3391-011 FWD TUBE ASSEMBLY PARTS LIST

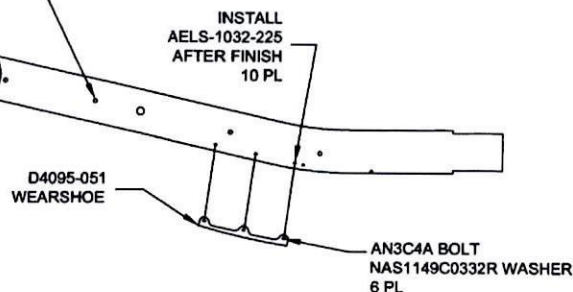
QTY -011	PART NUMBER	DESCRIPTION
X	D3391-011	FWD TUBE ASSEMBLY
1	D3391-1	TUBE
1	D3401-041	TOW CAP
9	D3670-4200	SPACER
4	D3672-1	WASHER
1	D4095-051	WEARSHOE
10	AELS-1032-225	INSERT
10	AN3C4A	BOLT
10	NAS1149C0332R	WASHER

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	ML	EUGENE, OR	
CHECKED	CP	DRAWING NO.	REV. J
MFG. APPR.		D3391	SHEET 3 OF 11
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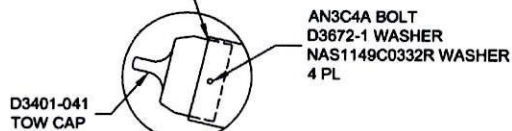
INSTALL D3670-4200 SPACER
SEAL WITH MAGNOBOND 6398
GRIND FLUSH
PRIOR TO PAINTING
4 PL

DETAIL B



D3391-021 FWD TUBE ASSEMBLY
ASSEMBLY DETAIL

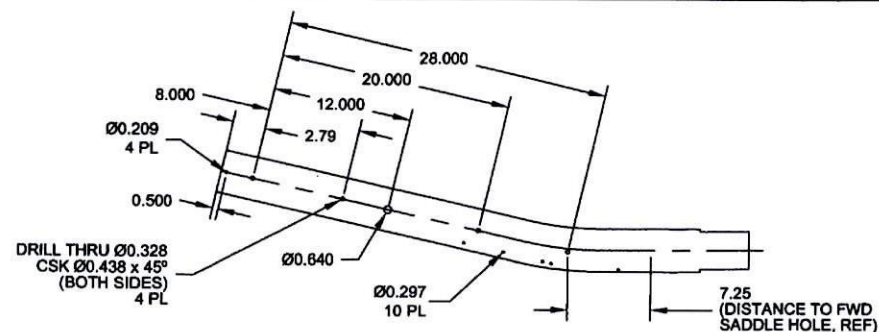
SEAL WITH
SIKAFLEX-241/-291



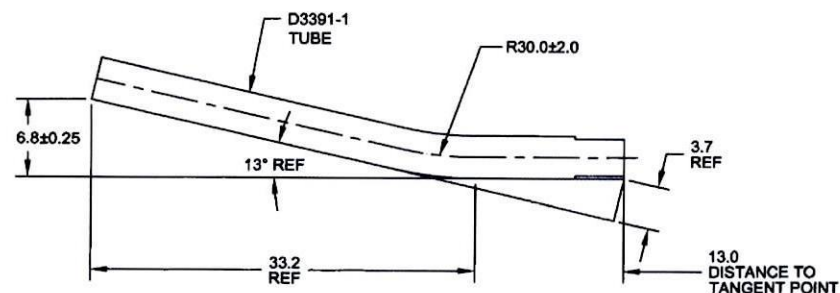
DETAIL B
SCALE 2X

D3391-021 FWD TUBE ASSEMBLY PARTS LIST

QTY -021	PART NUMBER	DESCRIPTION
X	D3391-021	FWD TUBE ASSEMBLY
1	D3391-1	TUBE
1	D3401-041	TOW CAP
4	D3670-4200	SPACER
4	D3672-1	WASHER
1	D4095-051	WEARSHOE
10	AELS-1032-225	INSERT
10	AN3C4A	BOLT
10	NAS1149C0332R	WASHER



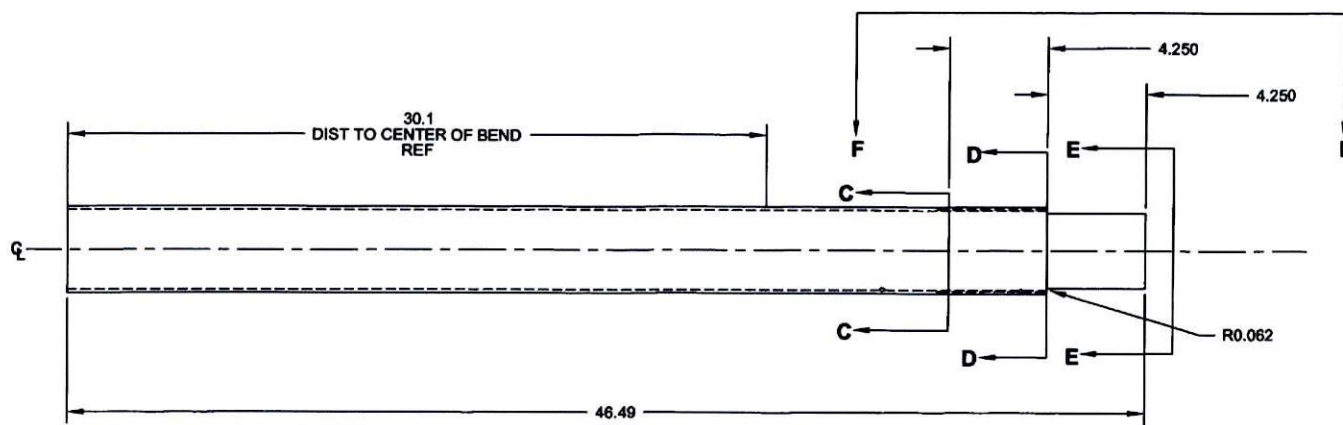
D3391-021 DRILLING DETAIL



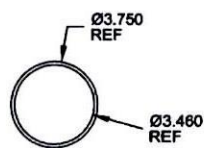
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(MAKE FROM D3391-1)

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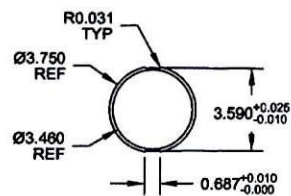
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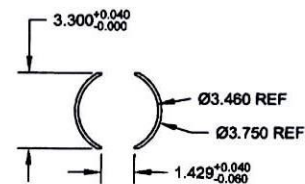
D3391-1 TUBE
(MAKE FROM D6013-047 SKIDTUBE MATERIAL)



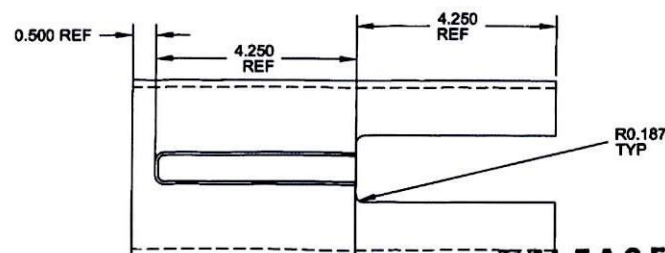
SECTION C-C



SECTION D-D



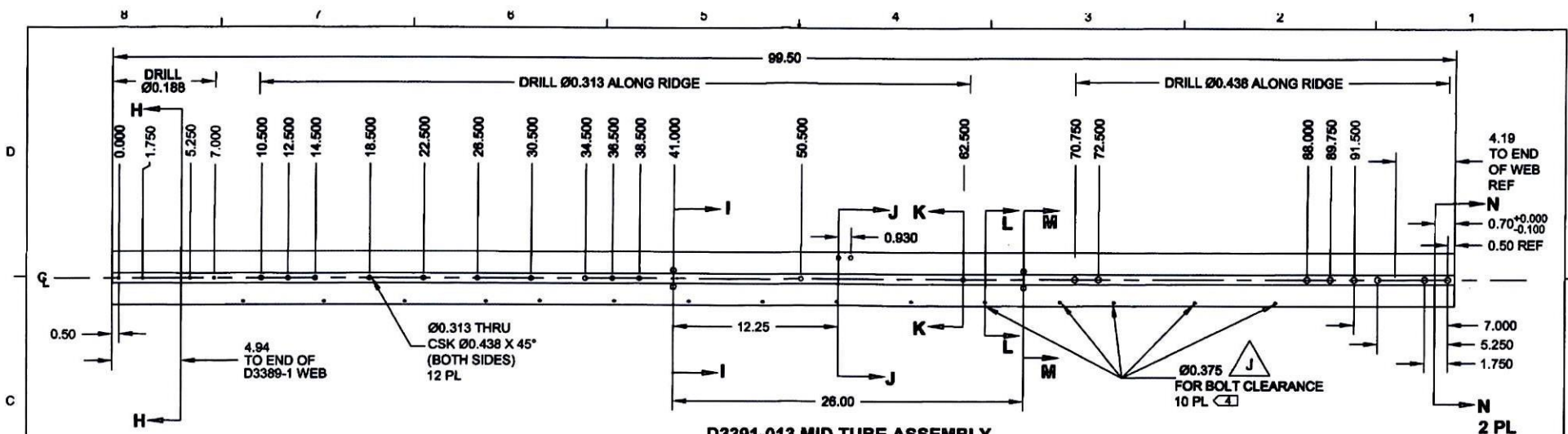
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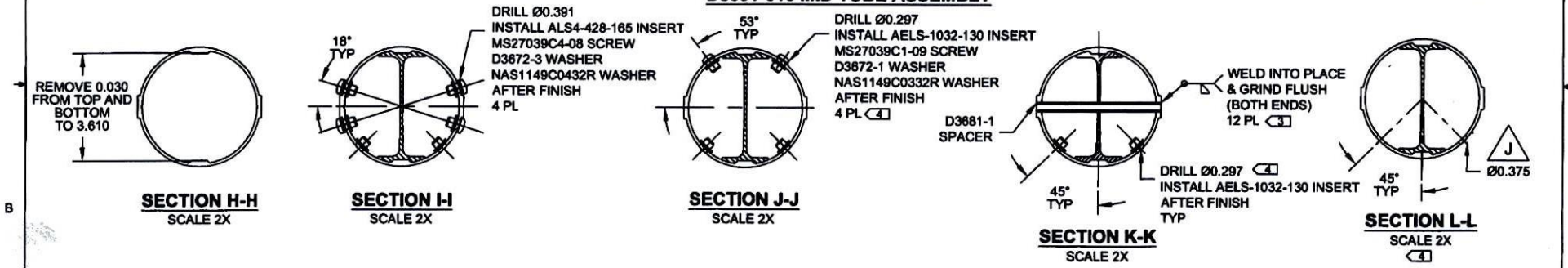
VIEW F-F
SCALE 2X

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2016-04-28

DESIGN	PH	DART AEROSPACE USA, INC	
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CHECKED	CP	DRAWING NO.	REV. J
MFG. APPR.	<i>CP</i>	D3391	SHEET 5 OF 11
APPROVED	<i>CP</i>	TITLE	SCALE
DE APPR.	<i>CP</i>	412 FLOAT SKIDTUBE	NTS
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D3391-013 MID TUBE ASSEMBLY



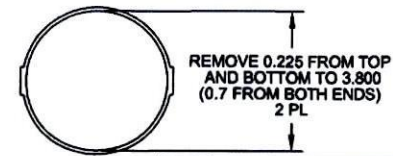
D3391-013 MID TUBE ASSEMBLY PARTS LIST

QTY -013	PART NUMBER	DESCRIPTION
X	D3391-013	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
1	D3389-1	WEB
4	D3672-1	WASHER
4	D3672-3	WASHER
12	D3681-1	SPACER
24	AELS-1032-130	INSERT
4	ALS4-428-165	INSERT
4	MS27039C1-08	SCREW
4	MS27039C4-08	SCREW
4	NAS1149C0332R	WASHER
4	NAS1149C0432R	WASHER



D3391-013 MID TUBE ASSEMBLY

- 1) MATERIAL: MAKE FROM D2500-1-100
- 2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/-291 PER QSI 015
- 3) WELDING: PER DART QSI 004
- 4) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 AND Ø0.375 HOLES FOR WEARSHOE INSERTS AND NUTPLATES. CBORE AS NOTED AND INSTALL INSERT/NUTPLATES EXCEPT WHERE INDICATED.

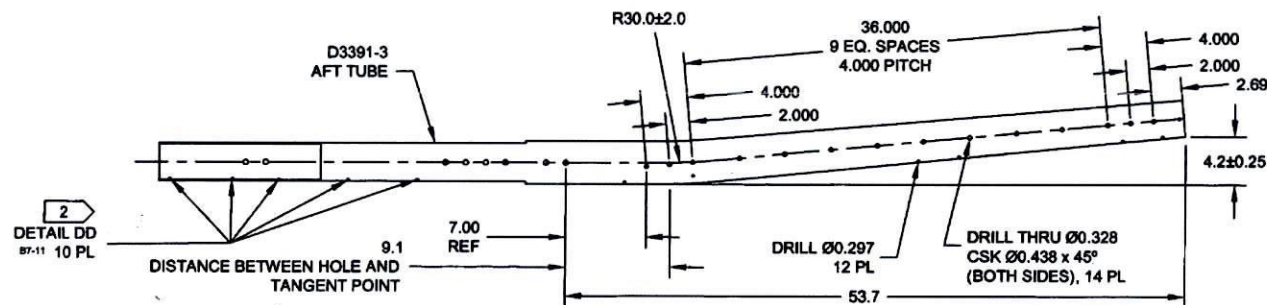
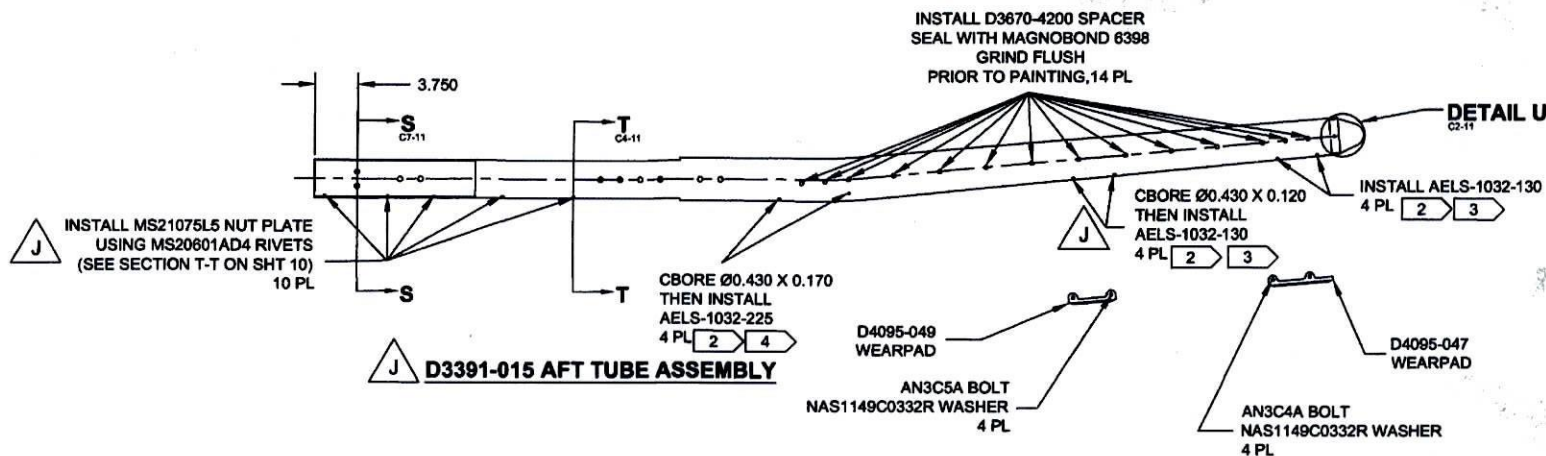


SECTION N-N
SCALE 2X

DESIGN	PH
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MFG. APPR.	
APPROVED	
DE APPR.	
DATE	16.01.14

DART AEROSPACE USA, INC EUGENE, OR	
DRAWING NO. D3391	REV. J SHEET 6 OF 11
TITLE 412 FLOAT SKIDTUBE	SCALE NTS
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D3391-015 AFT TUBE ASSEMBLY PARTS LIST

QTY	PART NUMBER	DESCRIPTION
X	D3391-015	AFT TUBE ASSEMBLY
1	D2646	AFT CAP
1	D3391-3	AFT TUBE
14	D3670-4200	SPACER
2	D3672-1	WASHER
1	D4095-049	WEARPAD
1	D4095-047	WEARPAD
8	AELS-1032-130	INSERT
4	AELS-1032-225	INSERT
4	ALSA-426-165	INSERT
6	AN3C4A	BOLT
4	AN3C5A	BOLT
20	MS20601AD4	RIVET, BLIND
10	MS21075L5	NUT PLATE, FLOATING
10	NAS1149C0332R	WASHER

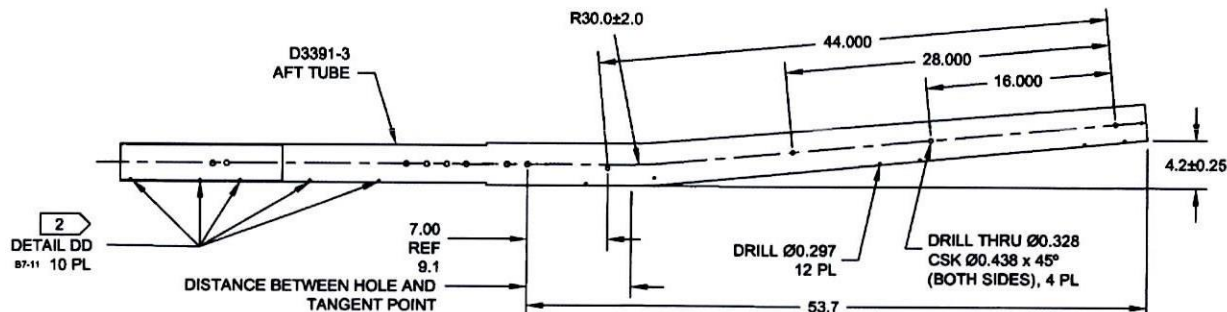
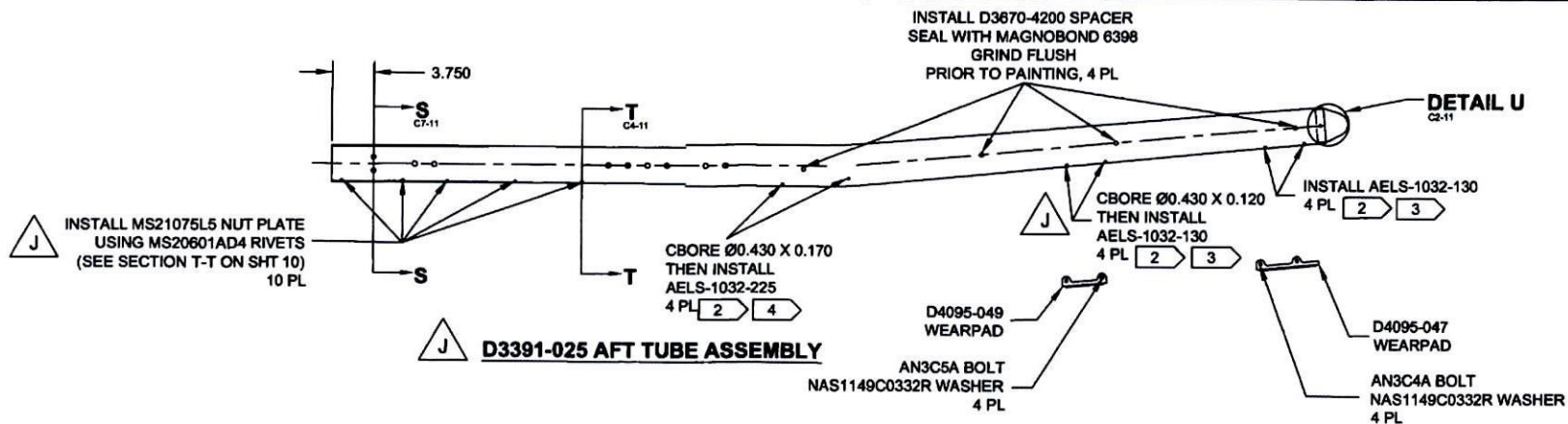
NOTES:

- 1) COAT ALL EXPOSED FASTENERS WITH LPS "LPS PROCYON"
- 2) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 AND Ø0.375 HOLES FOR WEARSHOE INSERTS AND NUTPLATES. CBORE AS NOTED AND INSTALL INSERT/NUTPLATES EXCEPT WHERE INDICATED.
- 3) ENSURE WALL THICKNESS IS BETWEEN 0.070 AND 0.130 BEFORE INSTALLING INSERT
- 4) ENSURE WALL THICKNESS IS BETWEEN 0.130 AND 0.225 BEFORE INSTALLING INSERT

BENDING AND DRILLING DETAIL

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D3391-025 AFT TUBE ASSEMBLY PARTS LIST

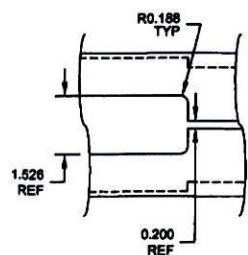
QTY	PART NUMBER	DESCRIPTION
X	D3391-025	AFT TUBE ASSEMBLY
1	D2648	AFT CAP
1	D3391-3	AFT TUBE
4	D3670-4200	SPACER
2	D3672-1	WASHER
1	D4095-049	WEARPAD
1	D4095-047	WEARPAD
8	AELS-1032-130	INSERT
4	AELS-1032-225	INSERT
6	AN3C4A	BOLT
4	AN3C5A	BOLT
20	MS20601AD4	RIVET, BLIND
10	MS21075L5	NUT PLATE FLOATING
10	NAS1149C0332R	WASHER

NOTES:

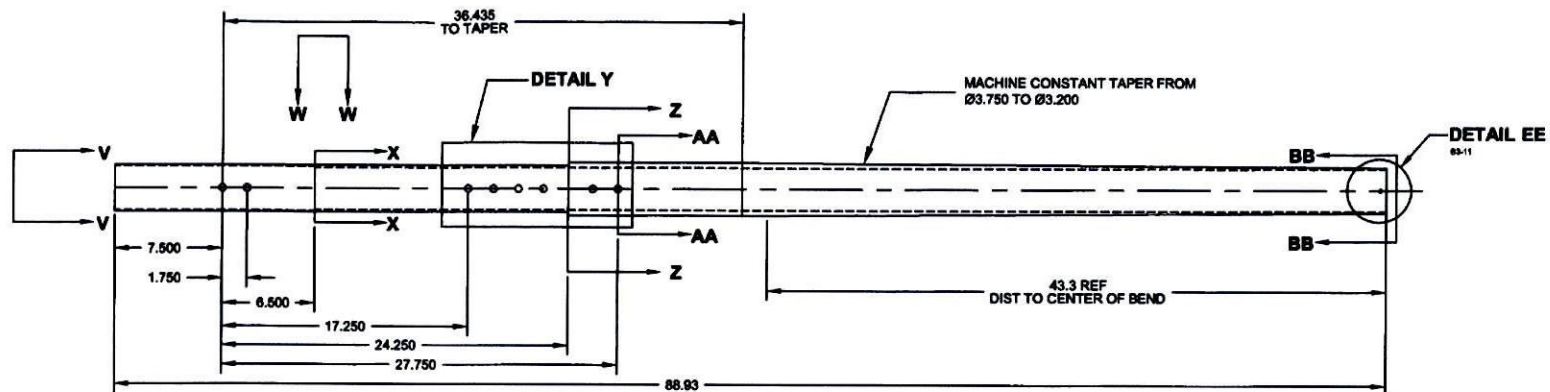
- 1) COAT ALL EXPOSED FASTENERS WITH LPS "LPS PROCYON"
- 2) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 AND Ø0.375 HOLES FOR WEARSHOE INSERTS AND NUTPLATES. CBORE AS NOTED AND INSTALL INSERT/NUTPLATES EXCEPT WHERE INDICATED. USE NUT PLATE DRILL JIG IF REQUIRED.
- 3) ENSURE WALL THICKNESS IS BETWEEN 0.070 AND 0.130 BEFORE INSTALLING INSERT
- 4) ENSURE WALL THICKNESS IS BETWEEN 0.130 AND 0.225 BEFORE INSTALLING INSERT

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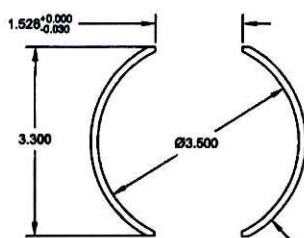
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MFG. APPR.		D3391	SHEET 9 OF 11
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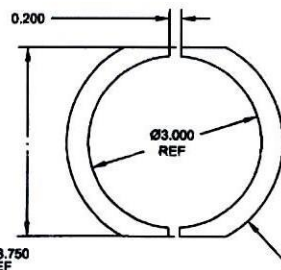
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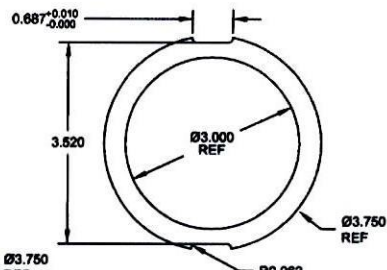
D3391-3 AFT DRILLING AND CUTTING DETAIL
(MAKE FROM D6014-090)



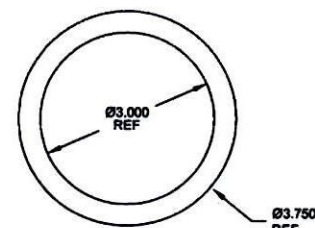
SECTION V-V
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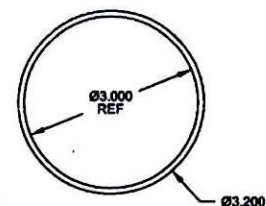
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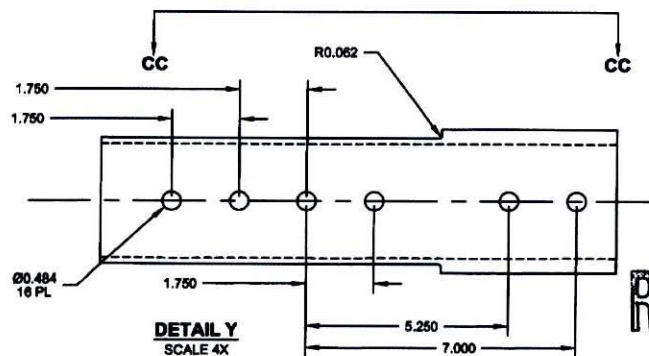
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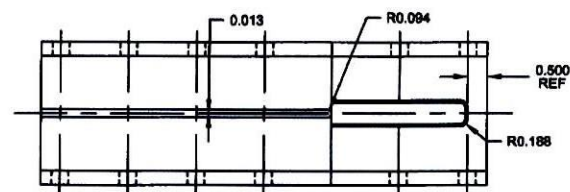
SECTION AA-AA
SCALE 4X



SECTION BB-BB
SCALE 4X



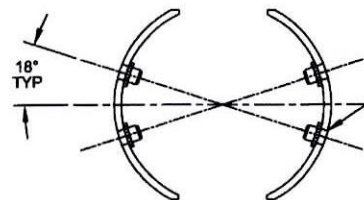
DETAIL Y
SCALE 4X



VIEW CC-CC

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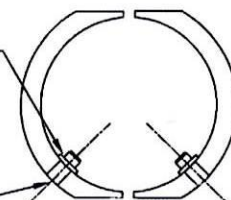
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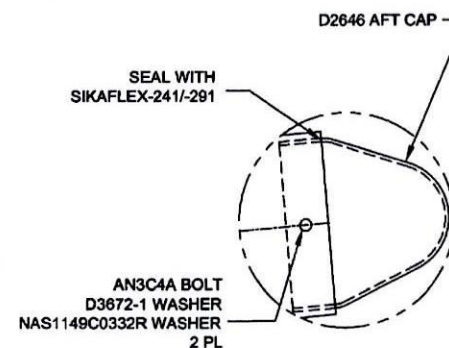
SECTION S-S D6-8.9
SCALE 5X

MS21075L5 NUTPLATE REF
USE DT8217 DRILL TEMPLATE
TO LOCATE HOLES AND OPEN
TO Ø0.375

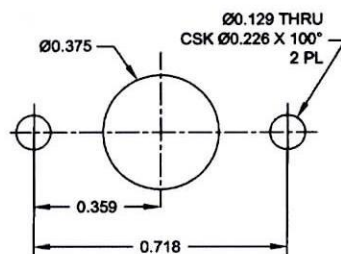
DRILL Ø0.391
CBORE Ø0.516 X 0.040 DEEP
INSTALL ALS4-428-165 INSERT
4 PL



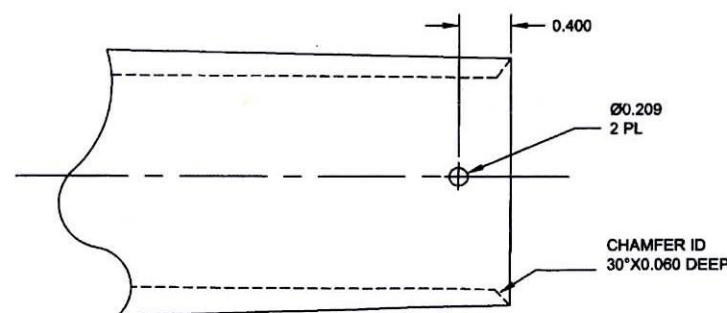
SECTION T-T D6-8.9
SCALE 5X
5 PL



DETAIL U D1-8.9
SCALE 5X



DRILLING DETAIL DD
SCALE 10X
D7-8.9



DETAIL EE D1-11
SCALE 2X

NOTES:
1) USE INDUSTRY STANDARD NUT PLATE DRILL JIG IF REQUIRED.

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